



MARKING INK

S-M99J4500-C

1. SCOPE

The material defined by this specification is a fast drying marking ink.

2. APPLICATION

The material is generally used as in identification on steel parts.

3. REQUIREMENTS

Material specification requirements are to be used for initial qualification of materials.

3.0 STANDARD REQUIREMENTS FOR PRODUCTION MATERIALS

Material suppliers and part producers must conform to the Company's Standard Requirements For Production Materials (WSS-M99P1111-A).

3.1 COLORS (similar to)

RAL 9002 or BS 2660, No. 9-102 White
RAL 6010 or BS 381 C, No. 221 Green
RAL 1012 or BS 381 C, No. 355 Yellow
RAL 3000 or BS 381 C, No. 537 Red
RAL 2000 or BS 381 C, No. 557 Orange
RAL 9005 or BS 381 C, No. 642 Black
RAL 5009 or BS 381 C, No. 107 Blue
RAL 4001 or BS 381 C, No. 796 Violet

3.2 NON-VOLATILE (FLTM BI 102-01)

Minimum 25%
Black
Red
Orange
Violet

Min 30%
Green
Yellow
White
Blue

3.3 VEHICLE

Synthetic resins and nitrocellulose.

3.4 VISCOSITY AS RECEIVED (FLTM BI 111-01)

90 +/- 10 s; FC-4 at 25 °C. Suitable for application by brush.

Date	Action	Revisions
2006 02 17	Revised	Inserted 3.0; Deleted 3.12 and 4
1994 12 19	Revised and Retyped	Was 5 pages
1982 08 13	Released	B/656707 TP





3.5 STABILITY

After 2 months storage at room temperature there shall be no gelling and/or heavy pigment sedimentation in the closed can.

3.6 ADHESION

Adequate adhesion to degreased steel.

3.7 TOXICITY

The material shall not contain toxic components, e.g. lead, or lead compounds, benzene, chlorinated hydrocarbons etc., in excess of that permitted by the safety regulations currently prevailing in the country or plant where the material shall be used. The use of cadmium is prohibited.

3.8 FLASH POINT

The flash point shall conform to the safety regulations applicable to the plant and/or country where the material shall be used.

3.9 GLOSS

No requirements

3.10 HIDING POWER

One application by brush to degreased steel shall completely hide the substrate.

3.11 DRYING TIME

Tack Free: Maximum 10 minutes at room temperature Completely Dry: Maximum 15 minutes at room temperature.